

Date: Friday, 6/23/2006 2:37:33 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACERS (5/16 THICK)
Job Number : 25967	
Estimate Number : 10248	
P.O. Number : N/A	Part Number : D2022103
This Issue : 6/23/2006 S.O. No. : N/A	Drawing Number : D2022 REV. --
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/27/2006 Type : MACHINED PARTS	Drawing Revision : --
Previous Run :	Material : N/A
Written By : <u>SEE COMMENT BEKW</u>	Due Date : 3/20/2006 Qty: 100 Um: Each
Checked & Approved By :	
Comment : Est D 02.03.07 Now made in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total : 3.2865 f(s)
6061T6 Round Bar .750"
Material: 6061-T6 (QQ-A-225/8)x.7500 bar
(M6061T6R0.750) Batch: M100559 66" MS 06/06/25

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
1- Note: .323 (P) Dia drill.
2-Turn Blank as per FolioFA207
3-Tumble & deburr any sharp edges as per dwg

SAD 06:07:02 1181
M.F. 06/06/30
MS 06/06/25 183

182

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/06/25 183

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S.G 06/07/07 181

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5717

06/07/07 181

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 6/23/2006 2:37:34 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (5/16 THICK)

Job Number: 25967

Part Number: D2022103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/07/07

Job Completion



11 06-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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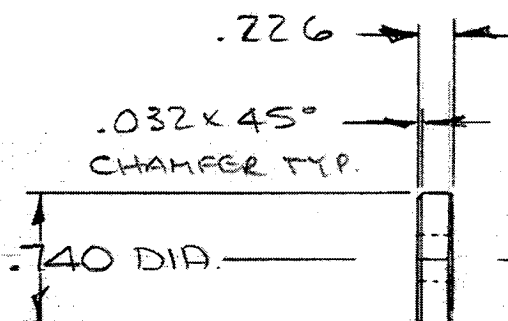
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

RELEASED
970119 BW

REFERENCE ONLY



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

D2022-103	SPACER 5/16	ALUM 6061-T6	QQ-A-250/B
D2022-101	SPACER 1/4	ALUM 6061-T6	QQ-A-250/B

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR																														
<table border="1"> <tr> <td colspan="2">CONTRACT NO.</td> <td colspan="3">DART AERO ACCESSORIES INC</td> </tr> <tr> <td>DRAWN BRADLEY</td> <td>DATE 4001/3</td> <td colspan="3">CLIENT</td> </tr> <tr> <td>DESIGN BRADLEY</td> <td></td> <td colspan="3">TITLE SPACERS</td> </tr> <tr> <td>STRESS</td> <td></td> <td colspan="3">CODE</td> </tr> <tr> <td>CHECKED</td> <td></td> <td colspan="3">DWG NO. D2022</td> </tr> <tr> <td>CLIENT</td> <td></td> <td colspan="3">SCALE 1:1 SHT 1 OF 1</td> </tr> </table>					CONTRACT NO.		DART AERO ACCESSORIES INC			DRAWN BRADLEY	DATE 4001/3	CLIENT			DESIGN BRADLEY		TITLE SPACERS			STRESS		CODE			CHECKED		DWG NO. D2022			CLIENT		SCALE 1:1 SHT 1 OF 1		
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REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523	QTY. REQUIRED	APPROVAL				
DRAWN		BASIC CODE						
APPROVED		DIA. DASH NO. IN-HEAD NEAR SIDE IN-HEAD FAR SIDE						
		D-DIMPLE DIGHTING OF SHEETS C-COUNTERSINK	LENGTH DASH NO. IN-SPOTWELD					
		BASIC CODES						
		BPM5204704D BB-45304126D						
DESCRIPTION OF CHANGE	<p>REQUIREMENTS — UNLESS OTHERWISE SPECIFIED</p> <table border="1"> <tr> <td>GENERAL</td><td>UNITS</td></tr> <tr> <td>1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125+ 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER INCH - 5-7742 5. HOLES PER AND 10281</td><td> <p>1. TOLERANCES — JOL 2. 530 JOL 3. 010 2. ANGLES 3. 10° 4. PARALLELISM 5. 0005 6. ECCENTRICITY 7. SYMMETRY ABOUT ALL M/C CENTRE LINES 505</p> </td></tr> </table>	GENERAL	UNITS	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125+ 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER INCH - 5-7742 5. HOLES PER AND 10281	<p>1. TOLERANCES — JOL 2. 530 JOL 3. 010 2. ANGLES 3. 10° 4. PARALLELISM 5. 0005 6. ECCENTRICITY 7. SYMMETRY ABOUT ALL M/C CENTRE LINES 505</p>	REPORT ALL DISCREPANCIES — DO NOT SCALE		
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